



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBEGM-745-064
Job Sheet 183847



Part No: RBEGM-745-064

Job Qty: 1 ea

Part Name: Removal/Installation-Motor Pump Cartridge (Forward Main Tank)



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/27/18

Job Tracking No:

Due Date: 10/18/18

Created By: Patrick Lussier

Type: Stock

Description:

Note: DWG RBEGM-745-064 Rev 0 IPP Rev A 18.04.10 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	1 pcs		10/18/18	0.00	0.00	Purchasing		<i>[Signature]</i> OCT 18 2018
110	Packaging	1 pcs		10/18/18	0.00	0.00	Packaging2		<i>[Signature]</i> OCT 18 2018
120	QC	1 pcs		10/18/18	0.00	0.00	QC6		38
130	Small Fab	1 pcs		10/18/18	0.00	0.50	Small Fab-4		<i>[Signature]</i> 9-29 DAS
140	QC	1 pcs		10/18/18	0.00	0.00	QC5		38
150	Packaging	1 pcs		10/18/18	0.00	0.00	Packaging3-1		<i>[Signature]</i> 9-29
160	QC21-FG	1 Ea		10/18/18	0.00	0.00	QC21		<i>[Signature]</i> OCT 23 2018

Part Op 100 - Issue PO to ARROW TECH MACHINE WORKS P/O: *041174* MANUFACTURE RBEGM-745-064 AS PER Descriptions: DWG -Certificate of conformity is required

130 - 1-Engrave placard RB41011 using marktronic engraver 2-Transfer drill Dart placard RB41011 into Pelican case APP-1400-E 3-Deburr holes and remove chips from case. 4-Rivet Dart placard to Pelican case 5-Glue foam to case and pack case as per DWG.

SEPT 27. 2018 x 1

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBEGM-745-064P	Removal/Installation-Motor Pump Cartridge (Forward Main Tank)	1 Ea (1 ea)	100-Purchasing	<i>5119483</i>
97524A032	Sealing Blind Rivet <i>N/A</i>	4 Ea (4 ea)	130-Small Fab	
APP-1400-E	Case	1 Ea (1 ea)	130-Small Fab	<i>5119562</i>
RB41011	Dart Tooling Placard, Aluminum	1 Ea (1 ea)	130-Small Fab	<i>5021040</i>
RBEGM-745-064-35	Bottom Tool Cushion use in case APP-1400-E	1 Ea (1 ea)	130-Small Fab	<i>5119563</i>
RBEGM-745-064-37	Top Tool Cushion use in case APP-1400-E	1 Ea (1 ea)	130-Small Fab	<i>5119564</i>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	RBEGM-745-064P	1	0	0
130-Small Fab	97524A032 <i>N/A</i>	4	999	0
	APP-1400-E	1	8	0
	RB41011	1	773	0
	RBEGM-745-064-35	1	0	0
	RBEGM-745-064-37	1	0	0



Container No: S119485



Part: RBEGM--745--064

Job No: 183847

Serial No/Batch: S119485

Revision: 0

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

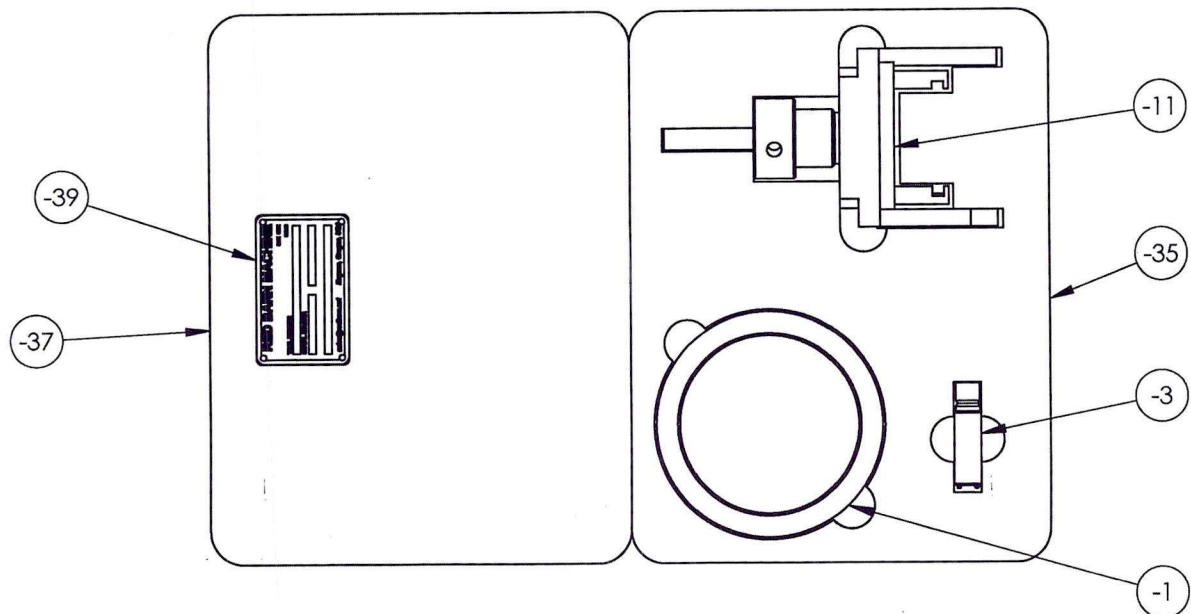
Date: 10/18/18

Part Specifications
Specifications could not be found.

Plex 9/27/18 1:59 PM dart.Lussier.Patrick

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REV		DESCRIPTION	REVISIONS		
DATE	INITIAL	APPROVED			

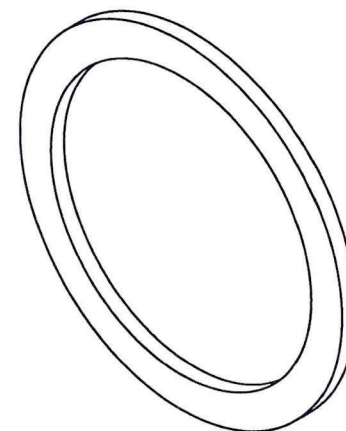
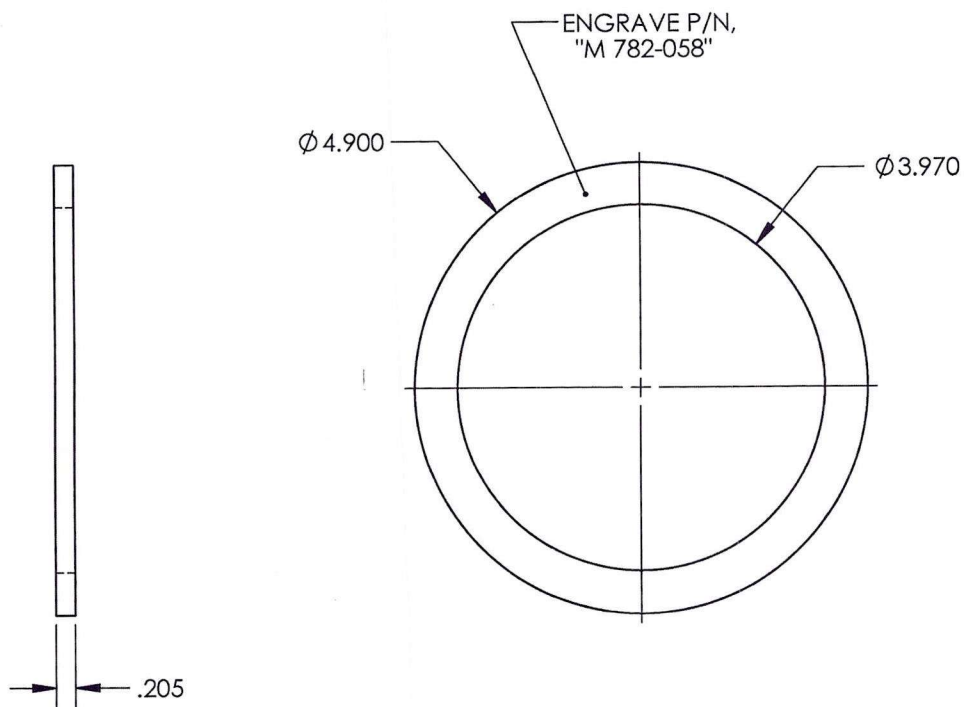


ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	RING	6061	Ø5 X 1/4	2
	X		-3	1	SOCKET WELDMENT			3
	1		-5		BASE	4140 Q & T	Ø5/8 X 2-3/8	4
	1		-7		SOCKET	STEEL	1/4 DRIVE 3/8 GRAINGER #6ECZ3(MODIFIED)	5
	2	B/O	-9		DOWEL PIN	STEEL	2mm X 10mm MCMaster-CARR #91595A026	3
X			-11	1	PULLER ASSY			6
1			-13		TOP	6061	1 X 1-5/8 X 4	7
1			-15		SIDE	6061	3/8 X 1-5/8 X 2-5/8	8
1			-17		SIDE 2	6061	3/8 X 1-5/8 X 2-5/8	9
1			-19		KNOB	6061	Ø1-7/8 X 1-7/8	10
1			-21		CROSS BRACE	1018	5/16 X 7/8 X 3-7/8	11
2			-23		ROD	STRESS PROOF	Ø1/2 X 1-1/4	12
1			-25		STUD	STEEL	M12 x 1.75 MCMaster-CARR #99055A135 (MODIFIED)	13
1		B/O	-27		BEARING	STEEL	FAG 51102	6
4		B/O	-29		SOCKET HEAD CAP SCREW	STEEL	M4 x .07 X 16 MCMaster-CARR #95263A273	6
2		B/O	-31		SOCKET HEAD CAP SCREW	STEEL	M4 x .7 X 12 MCMaster-CARR #95263A260	6
		B/O	-33	1	CASE		PELICAN #APP-1400-E	NS
			-35	1	BOTTOM TOOL CUSHION	Y-20, BLACK	3.95 X 9.08 X 11.98	14
			-37	1	TOP TOOL CUSHION	C200 FLAT, BLACK	1.2 X 9.08 X 11.98	15
		B/O	-39	1	RED BARN PLACARD	ALUMINUM	RB41009	NS

 RED BARN MACHINE		TITLE	
		FUEL CARTRIDGE PULLER	
DWG NO.		REV	
RBEGM-745-064			
MAT'L		DRAWN BY: GILBERT	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/32 .XX ± .01 ANGLES ± 5° .X ± .1		APPROVED <i>D. West</i> HEAT TREAT FINISH SPEC	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING		USED ON MODEL EC135	
SCALE 1:4	DATE 5/3/2012	SHEET 1 OF 15	

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REVISIONS				
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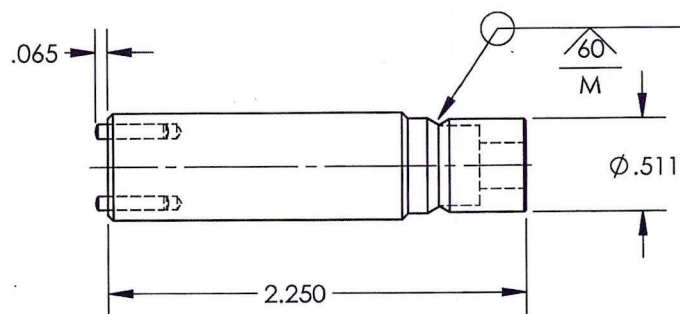
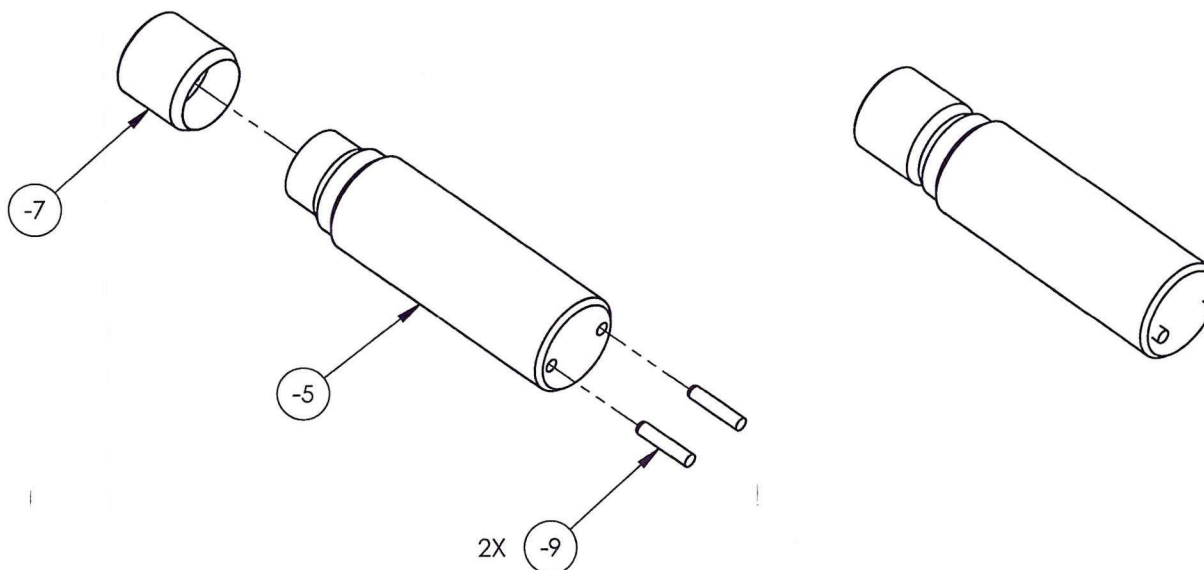


①
RING

 RED BARN MACHINE	
TITLE FUEL CARTRIDGE PULLER	
DWG NO. RBEGM-745-064-1	REV
MAT'L 6061	DRAWN BY: GILBERT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/32 .XX ± .01 ANGLES ± 5° .X ± .1	APPROVED <i>D. Weir</i> HEAT TREAT FINISH CLEAR ANODIZE
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	SPEC MIL-A-8625F, TYPE II, CLASS I USED ON MODEL EC135
SCALE 1:4	DATE 4/4/2012 SHEET 2 OF 15

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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED



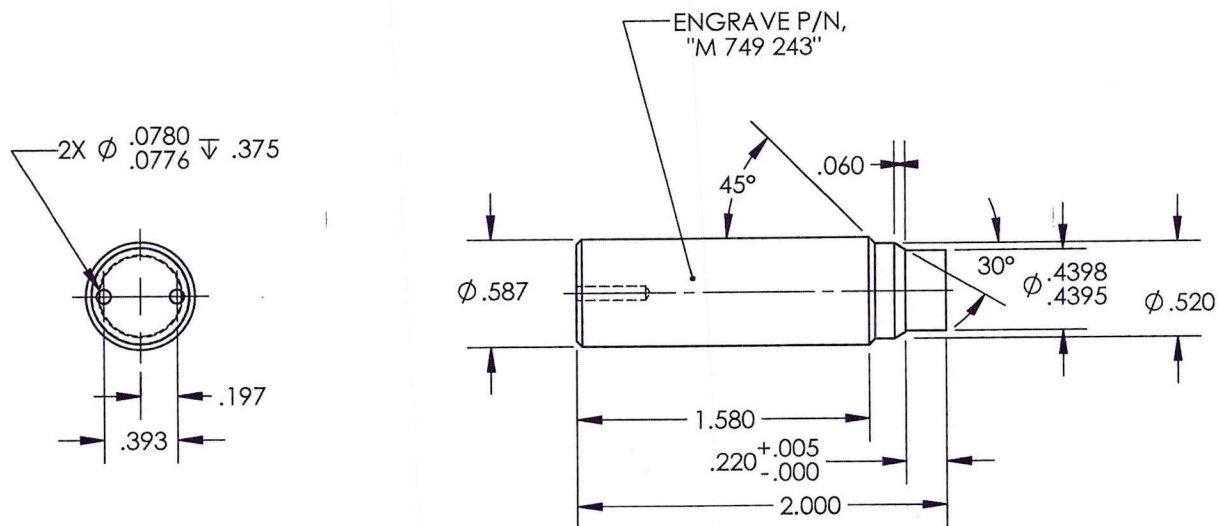
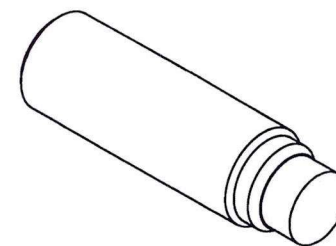
(-3)

SOCKET WELDMENT

 RED BARN MACHINE	
TITLE FUEL CARTRIDGE PULLER	
DWG NO. RBEGM-745-064-3	REV
MAT'L UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/32 .XX ± .01 ANGLES ± 5° .X ± .1	DRAWN BY: GILBERT APPROVED <i>D Wed</i> HEAT TREAT FINISH CAD PLATE YELLOW SPEC USED ON MODEL EC135
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 1:4	DATE 4/4/2012
SHEET 3 OF 15	

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REVISIONS			
REV	DESCRIPTION	DATE	INITIAL



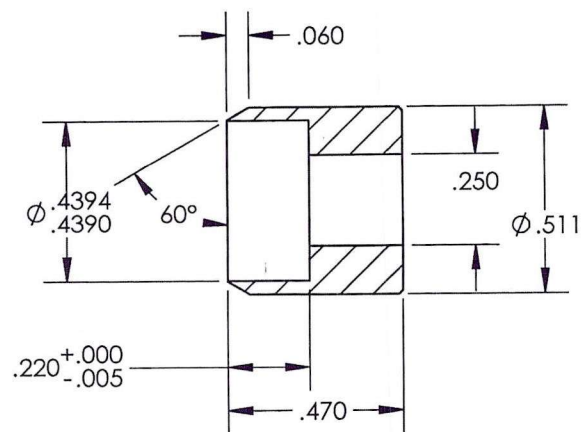
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BASE

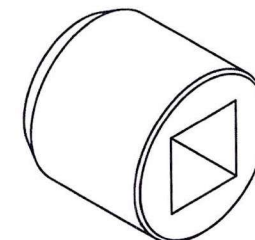
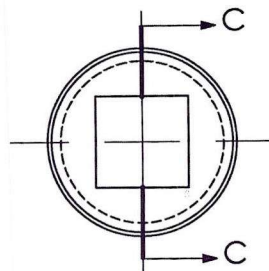
 RED BARN MACHINE	
FUEL CARTRIDGE PULLER	
DWG NO. RBEGM-745-064-5	
TITLE	
MAT'L 4140 Q & T	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
.XXX ± .005 FRACTIONS ± 1/32 .XX ± .01 ANGLES ± 5° .X ± .1	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 1:1	
DATE 4/4/2012	
SHEET 4 OF 15	
DRAWN BY: GILBERT	
APPROVED <i>D. Weil</i>	
HEAT TREAT FINISH	
SPEC	
USED ON MODEL	
EC135	

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REVISIONS			
REV	DESCRIPTION	DATE	INITIAL



SECTION C-C



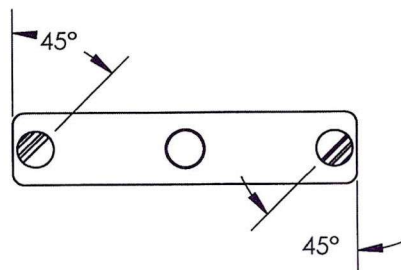
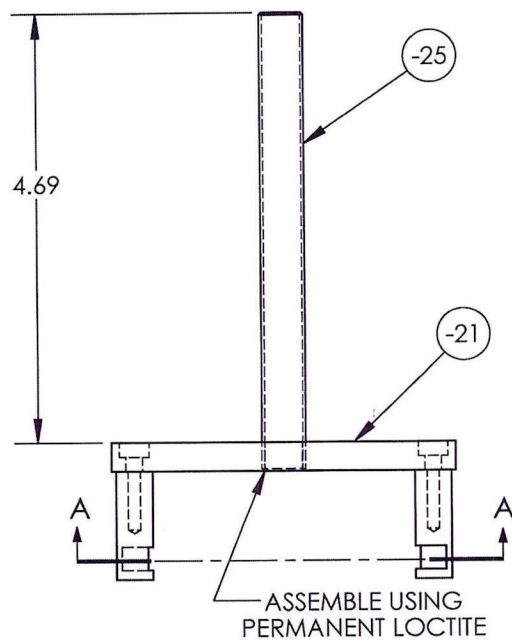
NOTE:
REMOVE ALL MANUFACTURE PART MARKINGS.

(-7)
SOCKET

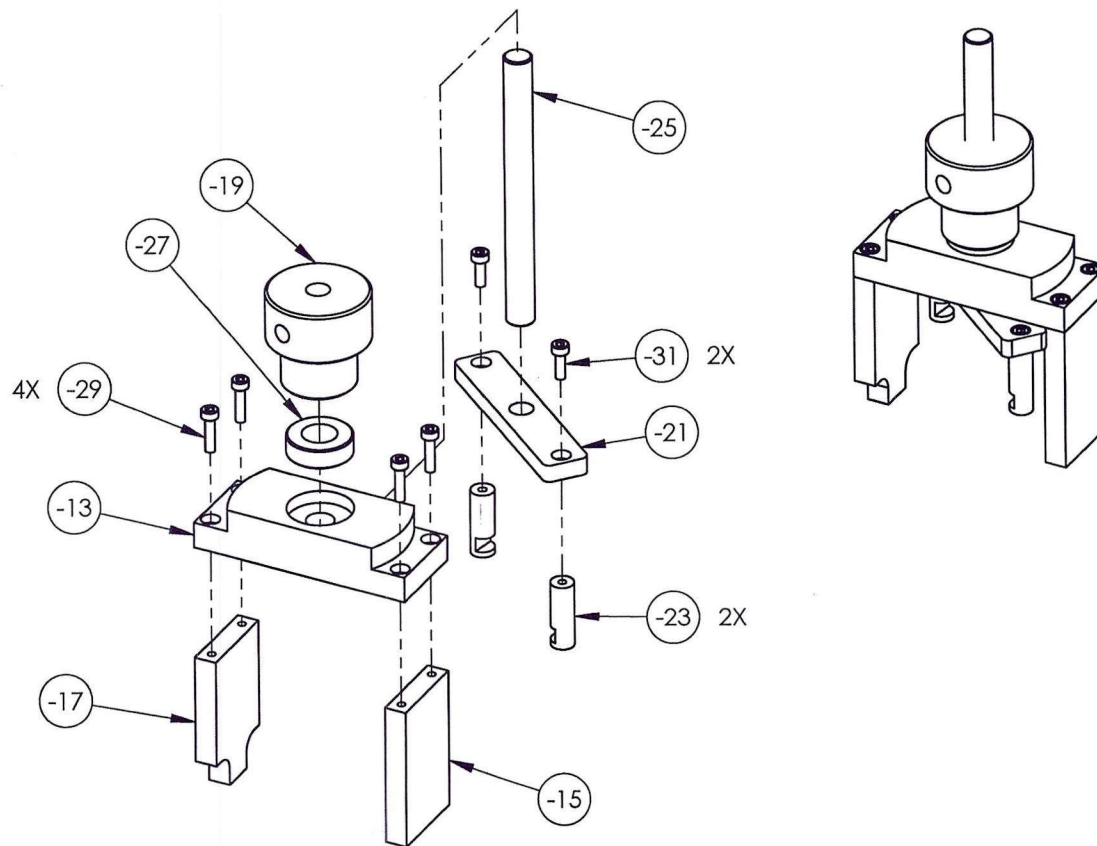
 RED BARN MACHINE	
TITLE FUEL CARTRIDGE PULLER	
DWG NO. RBEGM-745-064-7	REV
MAT'L STEEL	DRAWN BY: GILBERT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/32 .XX ± .01 ANGLES ± 5° .X ± .1 1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	APPROVED <i>D Wed</i> HEAT TREAT FINISH SPEC USED ON MODEL EC135
SCALE 2:1	DATE 12/14/2012 SHEET 5 OF 15

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REV		DESCRIPTION	DATE	INITIAL	APPROVED



SECTION A-A
SCALE 1 : 2

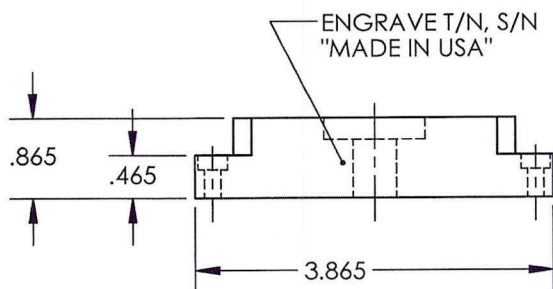
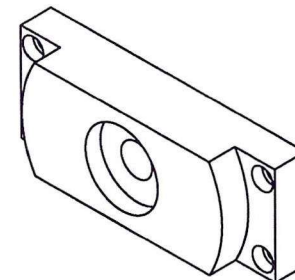
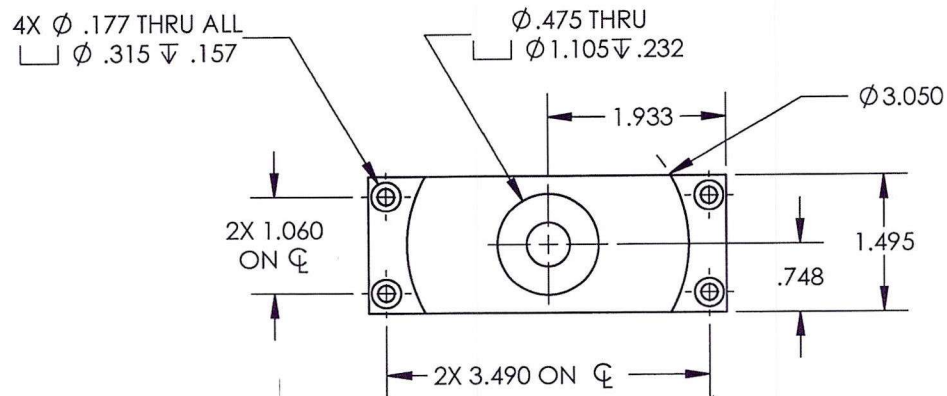


-11
PULLER ASSY

RED BARN MACHINE	
TITLE FUEL CARTRIDGE PULLER	
DWG NO. RBEGM-745-064-11	REV
MAT'L UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/32 .XX ± .01 ANGLES ± 5° .X ± .1 1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	DRAWN BY: GILBERT APPROVED <i>D Weid</i> HEAT TREAT FINISH SPEC USED ON MODEL EC135
SCALE 1:3	DATE 5/2/2012 SHEET 6 OF 15

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REV	DESCRIPTION	DATE	INITIAL	APPROVED



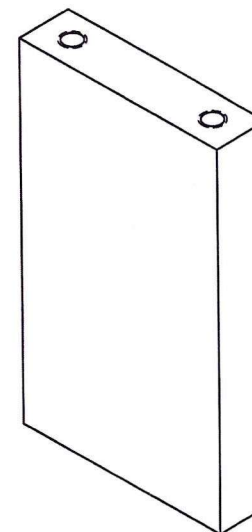
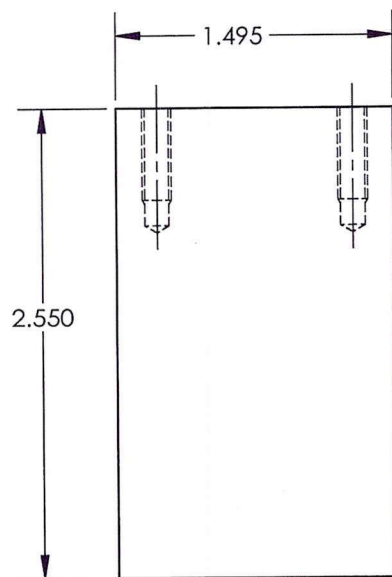
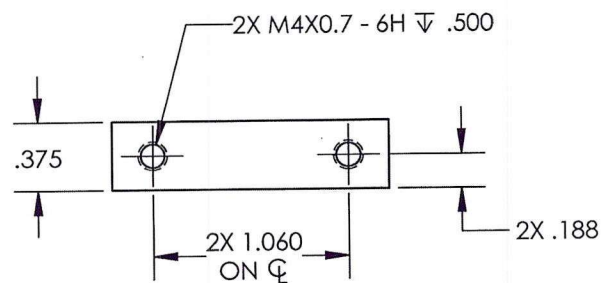
(-13)

TOP

RED BARN MACHINE	
TITLE FUEL CARTRIDGE PULLER	
DWG NO. RBEGM-745-064-13	REV
MAT'L 6061	DRAWN BY: GILBERT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Weil</i>
.XXX $\pm .005$	FRACTIONS $\pm 1/32$
.XX $\pm .01$	ANGLES $\pm 5^\circ$
.X $\pm .1$	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	SPEC MIL-A-8625F, TYPE II, CLASS I
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL EC135
SCALE 1:2	DATE 4/4/2012
SHEET 7 OF 15	

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REVISIONS			
REV	DESCRIPTION	DATE	INITIAL



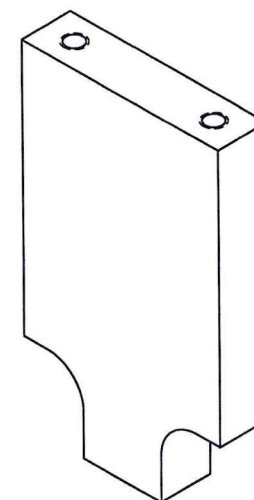
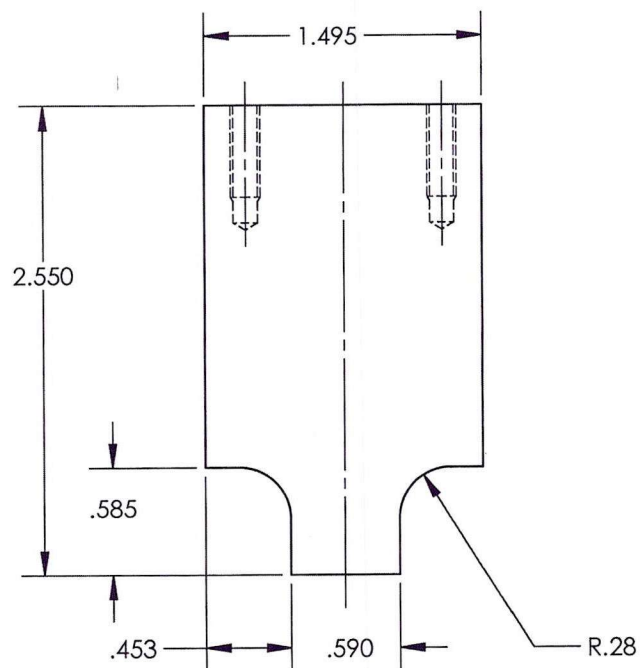
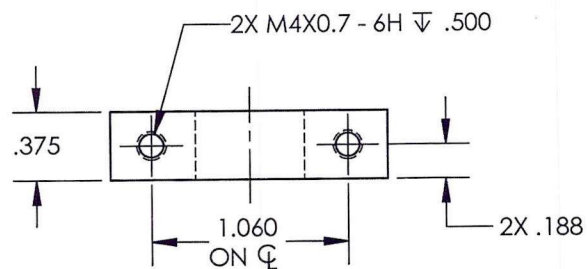
(-15)

SIDE

 RED BARN MACHINE	
TITLE FUEL CARTRIDGE PULLER	
DWG NO. RBEGM-745-064-15	REV
MAT'L 6061	DRAWN BY: GILBERT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Wed</i>
.XXX $\pm$.005	HEAT TREAT
.XX $\pm$.01	FINISH
.X $\pm$.1	CLEAR ANODIZE
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	SPEC MIL-A-8625F, TYPE II, CLASS I
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL
	EC135
SCALE 1:1	DATE 4/4/2012
SHEET 8 OF 15	

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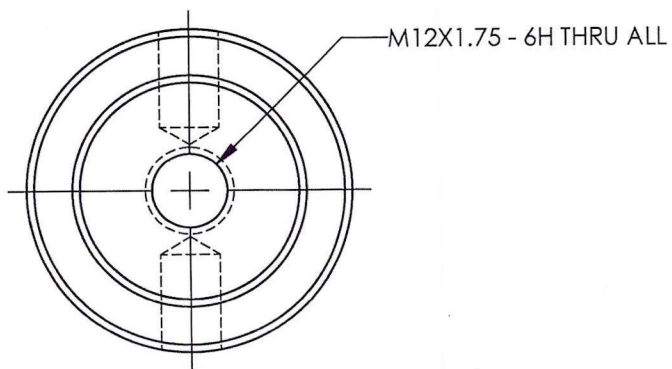
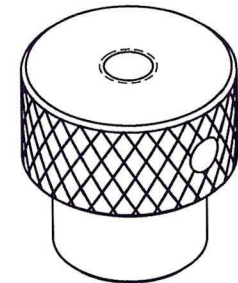
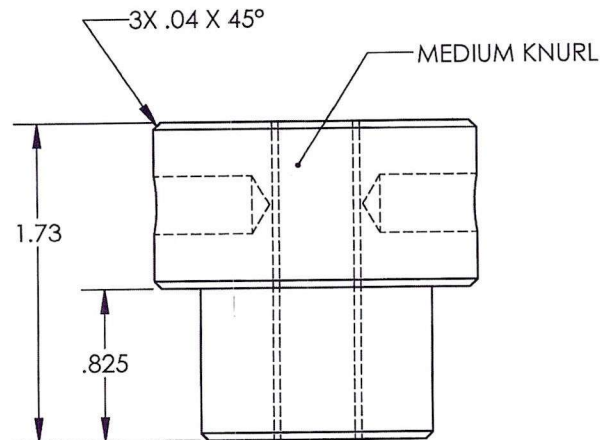
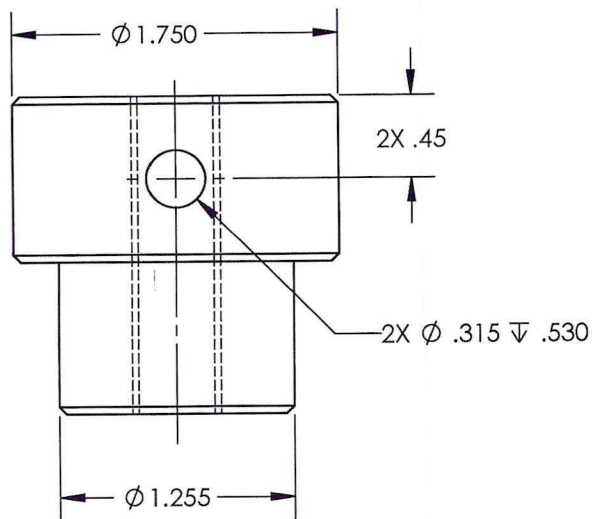
-17

SIDE 2

RED BARN MACHINE	
FUEL CARTRIDGE PULLER	
DWG NO. RBEGM-745-064-17	
MAT'L 6061	DRAWN BY: GILBERT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Weil</i>
.XXX $\pm$.005	FRACTIONS $\pm$ 1/32
.XX $\pm$.01	ANGLES $\pm$ 5°
.X $\pm$.1	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	SPEC MIL-A-8625F, TYPE II, CLASS I
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL EC135
SCALE 1:1	DATE 4/4/2012
SHEET 9 OF 15	

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REVISIONS			
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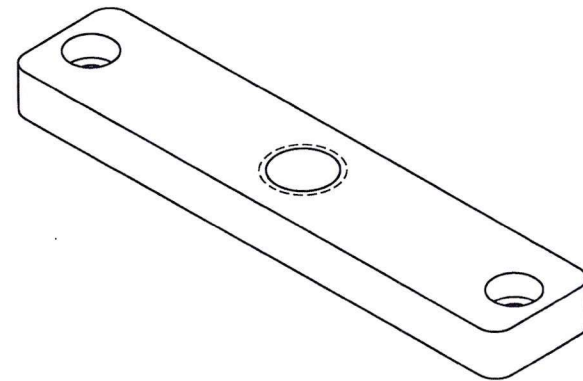
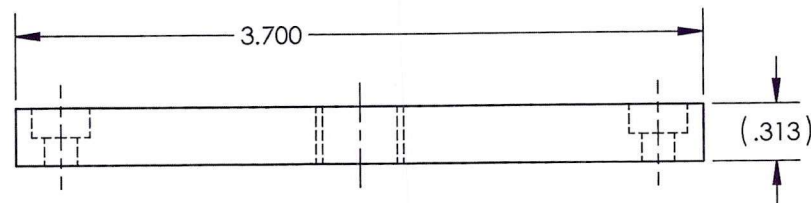
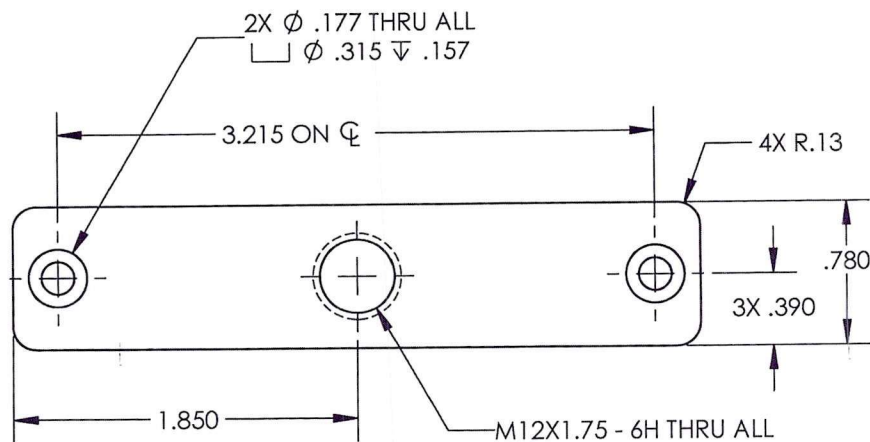


(-19)
KNOB

 RED BARN MACHINE	
TITLE FUEL CARTRIDGE PULLER	
DWG NO. RBEGM-745-064-19	REV 1
MAT'L 6061 UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX $\pm .005$ FRACTIONS $\pm 1/32$.XX $\pm .01$ ANGLES $\pm 5^\circ$.X $\pm .1$	DRAWN BY: GILBERT APPROVED <i>D Weil</i> HEAT TREAT FINISH CLEAR ANODIZE SPEC MIL-A-8625F, TYPE II, CLASS I USED ON MODEL EC135
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 1:1	DATE 4/4/2012 SHEET 10 OF 15

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REVISIONS			
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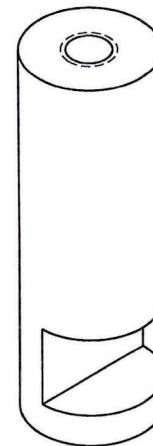
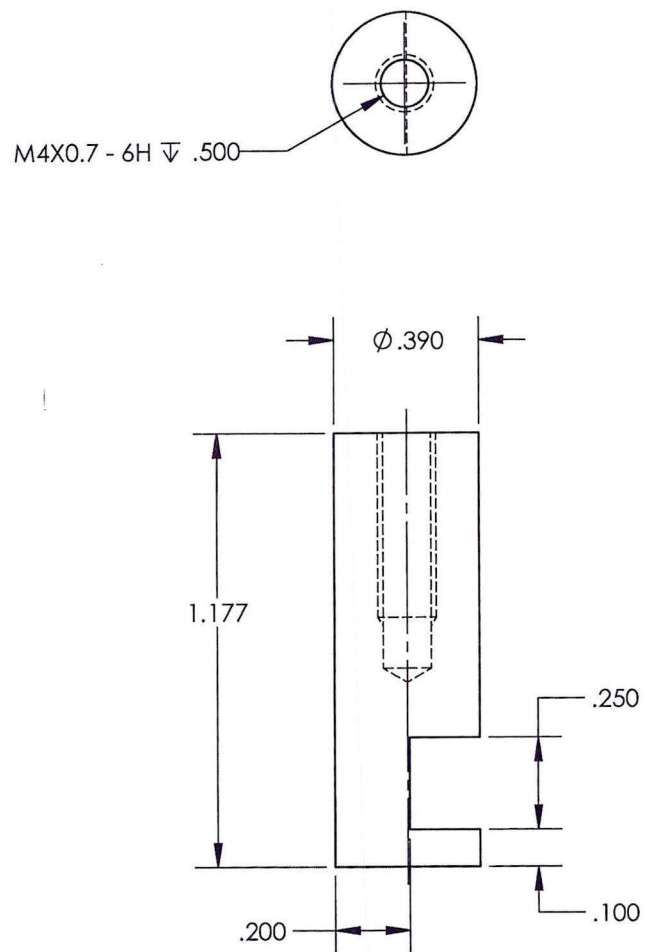


(-21)
CROSS BRACE

 RED BARN MACHINE	
TITLE FUEL CARTRIDGE PULLER	
DWG NO. RBEGM-745-064-21	REV
MAT'L 1018	DRAWN BY: GILBERT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/32 .XX ± .01 ANGLES ± 5° .X ± .1 1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	APPROVED <i>D West</i> HEAT TREAT FINISH BLACK OXIDE SPEC USED ON MODEL EC135
SCALE 1:1	DATE 5/2/2012 SHEET 11 OF 15

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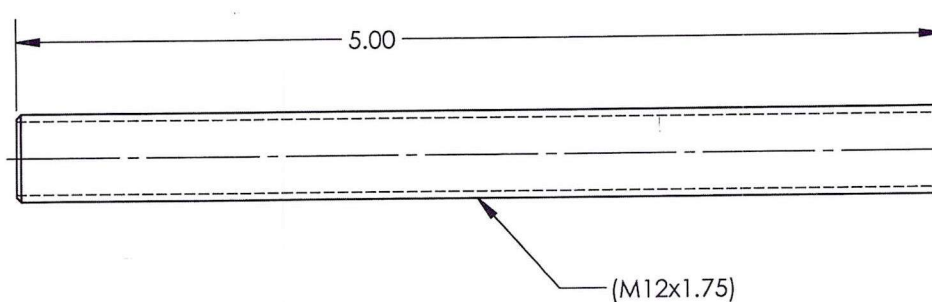
(-23)

ROD

RED BARN MACHINE	
TITLE FUEL CARTRIDGE PULLER	
DWG NO. RBEGM-745-064-23	REV
MAT'L STRESS PROOF UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/32 .XX ± .01 ANGLES ± 5° .X ± .1 1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	DRAWN BY: GILBERT APPROVED: <i>D Wed</i> HEAT TREAT FINISH: BLACK OXIDE SPEC USED ON MODEL EC135
SCALE 1:1	DATE 5/2/2012 SHEET 12 OF 15

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REV	DESCRIPTION	DATE	INITIAL	APPROVED

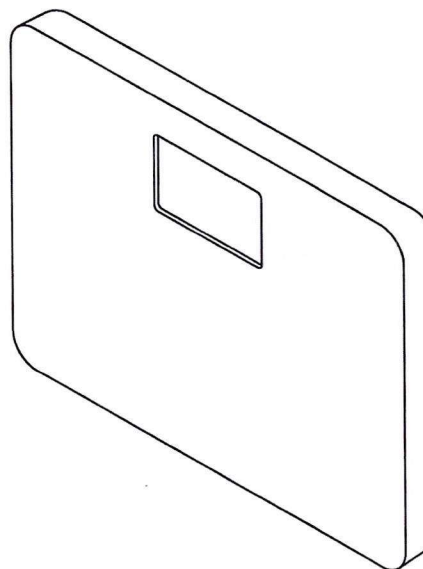
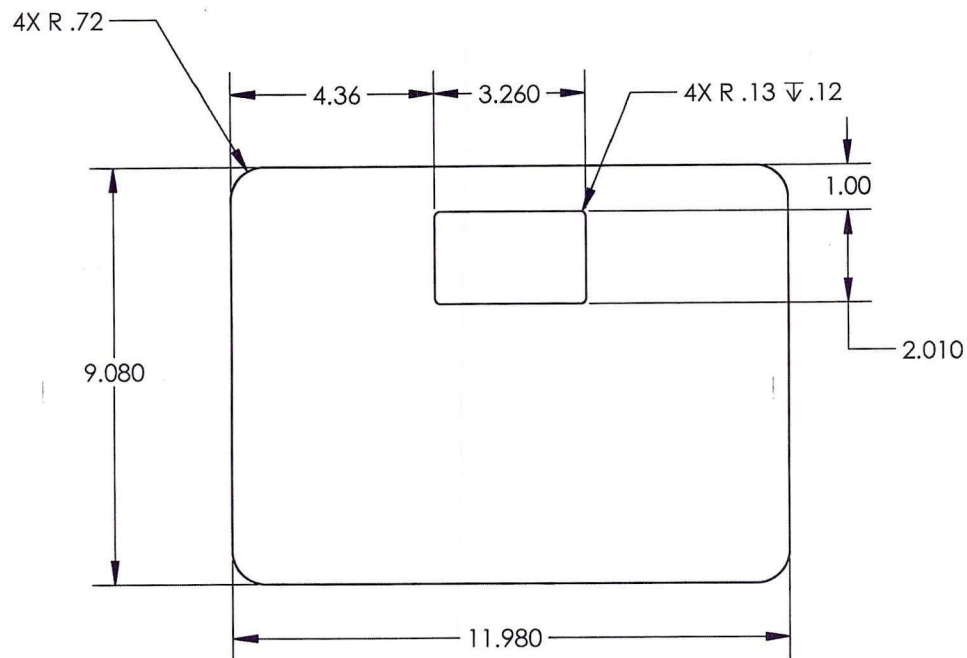


(-25)
STUD

 RED BARN MACHINE	
TITLE FUEL CARTRIDGE PULLER	
DWG NO. RBEGM-745-064-25	REV
MAT'L STEEL UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/32 .XX ± .01 ANGLES ± 5° .X ± .1 1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	DRAWN BY: GILBERT APPROVED <i>D Weil</i> HEAT TREAT FINISH BLACK OXIDE SPEC USED ON MODEL EC135
SCALE 1:1	DATE 4/4/2012
SHEET 13 OF 15	

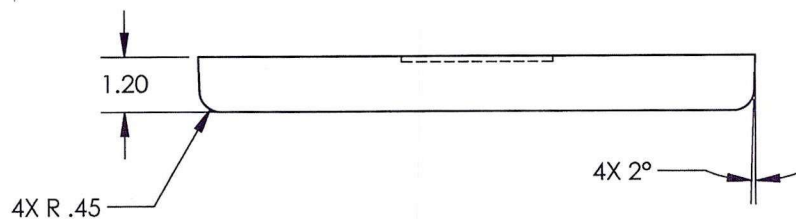
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REVISIONS			
REV	DESCRIPTION	DATE	INITIAL



-37

TOP TOOL CUSHION



RED BARN MACHINE	
FUEL CARTRIDGE PULLER	
DWG NO. RBEGM-745-064-37	
DRAWN BY: GILBERT	
APPROVED <i>D. West</i>	
HEAT TREAT FINISH SPEC	
USED ON MODEL EUROCOPTER	
SCALE 1:4	DATE 5/3/2012
SHEET 15 OF 15	

MAT'L C200 FLAT, BLACK

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES

.XXX ± .005 FRACTIONS ± 1/32
.XX ± .01 ANGLES ± 5°
.X ± .1

1. BREAK ALL SHARP EDGES .015 x 45°
OR .015R
2. DIMENSIONAL LIMITS APPLY AFTER
PLATING



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO041174

Supplier: ARR002-VU
Arrow Tech Machine Works
29751 E. Enid Road,
Unit C
Eugene, OR 97402 USA
Phone: 541-780-6938
Fax: 458-215-4938

PO No: PO041174
PO Date: 9/27/18
Due Date: 10/18/18
**Purchase Order
Revision:**
Revision Date:
Ship-To Contact: Phone:

Ship To:

Pynt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
1	183846	RBEGM- 745- 064P			Removal/Installation- Motor Pump Cartridge (Forward Main Tank)	Firmed	-	10/18/18	1 Ea	0 Ea	1 Ea	\$1,563.00/Ea	\$1,563.00
								OCT 18 2018					
2	183847	RBEGM- 745- 064P			Removal/Installation- Motor Pump Cartridge (Forward Main Tank)	Firmed	-	10/18/18	1 Ea	0 Ea	1 Ea	\$1,563.00/Ea	\$1,563.00
								OCT 18 2018					
Grand Total:												\$3,126.00	

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

A005 RIGHT OF ENTRY

A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)

A012 CHEMICAL AND PHYSICAL TEST REPORTS

A016 PERSONNEL QUALIFICATION

A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)

A026 CERTIFICATION OF MATERIAL CONFORMANCE

A041 QUALITY MANAGEMENT SYSTEM

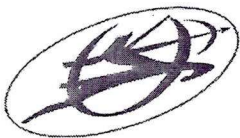
A042 DART NOTIFICATION BY SUPPLIER

A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS

Plex 9/27/18 2:08 PM dart.Lussier.Patrick



**PHGE Machineworks dba
Arrowtech Machineworks**
29751 E Enid Rd. Unit C
Eugene, Oregon 97402
Phone: (541) 780-6938
Fax: (458) 215-4938

Packing Slip

NO. 289

Date: 10/17/2018 ✓
PO Ref: 041174 ✓
Ship via: Fedex Priority

Bill To:
Dart Aerospace
1270 Aberdeen St. Hawkesbury, ON
CANADA K6A 1K7

Ship To:
Dart Aerospace
1271 Aberdeen St. Hawkesbury, ON
CANADA K6A 1K8

DAS
38
9-89

Qty	Item	Part No.
1 ✓	REMOVAL/INSTAL. MOTOR PUMP CART.	RBEGM-745-064 ✓
1 ✓	REMOVAL/INSTAL. MOTOR PUMP CART.	RBEGM-745-064 ✓

Received by: _____

Packaged by: AMP.

Checked by: CE

Thank You



ARROW TECH MACHINE WORKS

Certificate of Conformance

Your Purchase Order No: 041174 ✓ Dated: 10/17/2018

Our Order / Job No: 041174-01AWT Order Qty: 2 ✓

Part Name: FUEL CARTRIDGE PULLER

Part Number: RBEGM-745-064 ✓

Lot Size: N/A Ship Date: 10/17/2018

We certify that these parts shipped to you are of domestic or international manufacture and conform to all requirements of the Purchase Order. These parts have been manufactured and inspected in accordance with all required specifications, instructions and drawings. Any applicable specifications are listed below:

Drawing Number: RBEGM-745-064 Rev: 0

Material Size and Type: -1,-13,-15,-17,& -19/6061 ALUM; -5/4140 STEEL Q&T; -21/ 1018 STEEL; -23/STRESS PROOF STEEL

Material Specifications: STEEL: ASTM A108, ASTM A29; ALUM.: ASTM B221; STRESS PROOF STEEL: ASTM A108 ASTMA29

Heat Treatment: N/A

Plating/Finish: CLEAR ANODIZE: MIL-A-8625F, TYPE II, CLASS I; BLACK OXIDE: QMSI-6.2.2 B.O. REV D; ZINC PLATE: ASTM B66 TYPE I SC 2

Mercury Contamination: The material used to process this order has not come in contact with mercury or mercury bearing instruments.

Date: 10/17/18

Signed: Hemant M. Gadd

DAS
38
9-89

PHGE Machine Works LLC dba Arrow Tech Machine Works
29751 E. Enid Rd. Unit C Eugene, Oregon 97402
Main: (541) 780-6938 | Fax: (458) 215-4938
www.atechmachineworks.com